

Work Order ID 83437

83437

Page 1

April-18-12 8:16:42 AM

Item ID: D3453-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clevis

Stop *NS2*

Start Date: 18/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3453

Rev B

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA578

Rev: AA &

Dwg D3453 Rev: B

2- Deburr as per dwg D3453

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

160

QC8- Inspect parts - second check

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 83437

April-18-12 8:16:42 AM

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Page 2

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Accept

N900040100

Setup Start

NS1

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Item Name: Clevis

Stop

NS2

Start Date: 18/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: W9

0.00

170

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

20x

SP
12-5-30

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/30

ME
12-05-30

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Picklist Print

April-18-12 8:16:45 AM

Page 1

Work Order ID: 83437

83437

Parent Item: D3453-3

D3453-3

Parent Item Name: Clevis

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	23.7400	0.2452	4.904			

M304R1 250

304 round bar 1.250

Location

Loc Qty

Loc Code

MAT029

23.74

105872

12.33

108156

1.68

1111018

9.73

5 ml 12/05/23

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DART AEROSPACE LTD		Work Order:	83437
Description: Clevis		Part Number:	D3453-3
Inspection Dwg: D3453 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.012/-0.001	1.129	—		Ver M1-b6	
Ø0.755	+0.002/-0.005	0.7517	—		"	
2.74	+/-0.030	2.746	—		"	
1.220	+/-0.010	1.215	—		"	
1.00	+/-0.030	1.000	—		"	
0.500	+0.010/-0.000	.504	—		"	
Ø0.375	+0.006/-0.001	0.380	—		"	
Ø0.129	+0.005/-0.001	0.129	—		"	
0.625	+/-0.010	.624	—		"	
0.450	+/-0.010	.448	—		"	

Measured by:	mk
Date:	12/05/23

Audited by:	B.A
Date:	12/05/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev B	KJ	

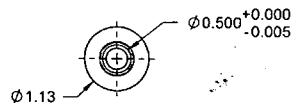
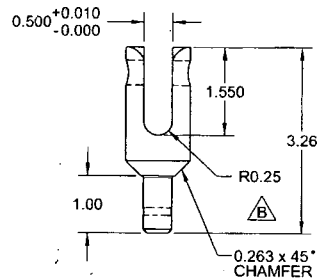
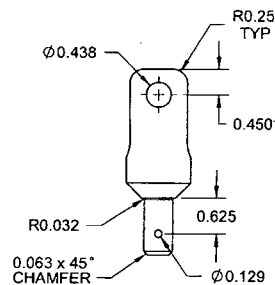
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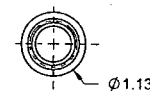
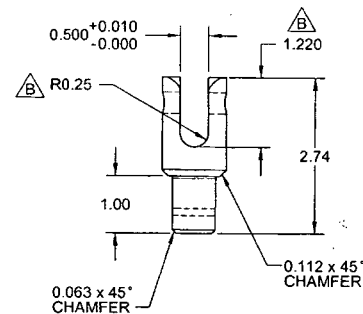
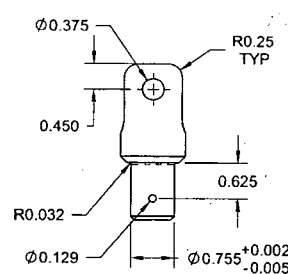
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NOTE: Date & initial all entries



D3453-1 CLEVIS



D3453-3 CLEVIS

RELEASED
3/25/10

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 03437 MLJ
12/04/18

B	DRAWING UPDATED TO CURRENT STANDARDS: R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3453	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CLEVIS	NTS
DATE	09.05.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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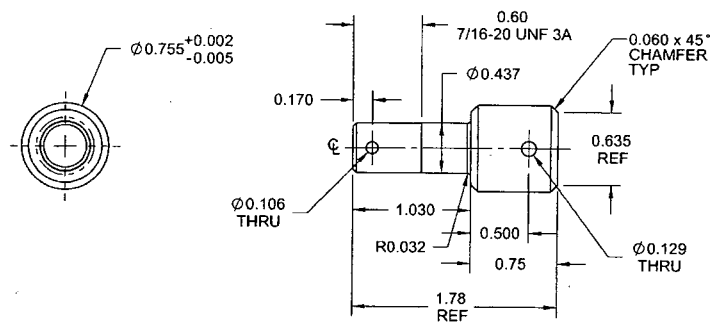
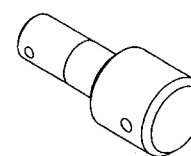
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NOTE: Date & initial all entries

83432



D3453-5 PLUG

- D3453-5 NOTES:**
- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

RELEASED
09/08/25 MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3453	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLEVIS	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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